July-11-13 2:42:30 PM Item ID: D3189-1 Accept \*N900040100\* Setup Start Revision ID: Chaffing Shield Item Name: \*20\* 7/11/13 Start Date: **Start Qty: 20.00 Cust Item ID:** Required Date: 7/25/13 Req'd Qty: 20.00 \*20\* Customer: Reference: Run Date: 13-07-11 Tooling: Approvals: Date: SPC (Y/N): Date: QC: Date: Sequence 1D/ Operation Tool# Plan Reject Set Up/ Tool ID Accept Work Center ID Description Code Qty Qty **Run Hours** 

Draw Nbr **Revision Nbr** D3189 C 100 0.00 SHEAR -20- -0- JM3.08-14 \*100\*

Waterjet

Memo

0.00

Stop

Reject

Number

Insp.

Stamp

FLOW CNC Waterjet

1-Cut as per Dwg Dwg Rev: Prog Rev:

2-Deburr if necessary

103

QC2- Inspect parts off machine FAI/FAIB

0.00

\*102\*

QC

Memo

0.00

Quality Control

DQA:	_	_ Date:						_				DART
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDA		ork Order up	odate only	AEROSPACE
Work Order					DISPOSITION			А	GAINST DE	PARTMENT,	PROCESS	-
Part No	).			<del></del>	Rework Scrap Use-as-is Suspected Unapproved			Machining Sr moforming F	osstube mall Fab inishing mposite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Desc	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description	n	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												
						FAI	ULT CA	TEGORY			·	
Landing	_				General					· <del></del>		<del></del>
-	Bending			-	Bend Bond /Barrier	-	1	Program		Outside Dime	<u> </u>	Pressure/Forced
<u> </u>	-	ot Concer	itric	-	BOM/Route	┡	Grain		-	Over/Under	<b> -</b>	Set-up
  -	Cracks	ml./0:==!=	/\Almain	-	Broken/Damage/Defect	<del> </del>	Hardwa		F	Part Incorrec		Temperature/Cure
-	<b>⊣</b>	nk/Ripple	/wave	-	Burrs	┝	1 '	ion Incomplete/Unqualit	<b>├</b>	Part Lost/Mi	ssing	Weld
-	Cuffs			-	Countarink	—	4	tions Incomplete/Unclea	hr	Part Moved	<u></u>	Wrong Stock Pulled
<u> </u>	Crushing Heat Tre			-	Countersink Cut Too Short	_	1	gned/off center	$\vdash$	Positioned W		Tother
<u> </u>	_	at on Strip in	Tubo	-	Drawing	—	Mislabe Misread		<u></u>	Power Loss/S	oni Be	Other
<u> </u>	Marks/C	•	Tube	 	Drill Holes	-	Off-set					
-		Sequence		}-	Finish	⊢	-	Calibration		_		······································
	<b>-</b> ₁ -	vist in Tub			Fit/Function	—	4	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

July-11-13 2:42:30 PM

Item 1D: D3189-1 Accept \*N900040100\* Setup Start **Revision ID:** Chaffing Shield Item Name: Start Qty: 20.00 Start Date: 7/11/13 **Cust Item ID:** Required Date: 7/25/13 Req'd Qty: 20.00 Customer: Reference: Run Tooling: Approvals: **Process Plan:** Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Accept Insp. Work Center ID Description Run Hours Qty Qty Number Code Stamp 105 QC8- Inspect parts - second check 0.00 \*105\* QC Memo Quality Control 110 0.00 Small Fab \*110\* Small Fab 0.00 Memo Small Fab 1- Roll as per Dwg D3189 120 QC5- Inspect part completeness to step on W/O \*120\* Memo Quality Control

DQA:			Date:	•		. WORK OBDED NON	ORK ORDER NON-CONFORMANCE / UPDATE						DART
QA Closed:			Date:			WORK ORDER NON	-(1	ONFO	RIVIAINCE / E		/ork Order up	date only	AEROSPACE
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part No				<u> </u>	Rework Scrap Use-as-is Suspected Unapproved		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		<del></del>	
Root					Desc	ription of work order update		Initial	A	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Des	cription	Date	Verificatio	n QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved												·	
							FΑ	ULT CAT	regory				
Landin	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe	ion Incomplete/li ions Incomplete, ned/off center eled	/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance et ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other		
_		Turning Se Wave/Twi	equence	e		Finish Fit/Function	-	-	Calibration Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

July-11-13 2:42:30 PM

Item ID: Revision ID: Item Name:	D3189-1 Chaffing Shi	eld		Accept	* <b>N</b> 900	<b>)*</b>	Setup S	Start Stop	*N: *N	S1* S2*	r r		
Start Date: Required Date: Reference:	7/11/13 : 7/25/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:							
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		ate:		F		Start Stop		R1' R2'	
Sequence ID/ Work Center II 130 *130* Packaging Packaging	<b>D</b>	Operation Description Identify as per dwg & Sto	ck Location <u>: X-FU</u> BU ASS'Y	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject lumber	Insp. Stamp DAS 05	
140 *140* QC Quality Control		QC21- Final Inspection -  Memo	Work Order Release	0.00				ML	Z_)		3-23	 W	-

13.8.72

DQA:	<del> </del>	_ Date:			-					•		1	APT
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / U		/ork Order up	odate onlv - [	$\neg$	AEROSPACE
					DISPOSITION					EPARTMENT		1	
Work Orde	ır:				<b>1</b>	a			Г				<del>.</del>
Part N	lo.				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	$\dashv$	Engineering Quality
					Use-as-is	1		noforming	Finishing		re/Packaging	ヿ	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite		Supplier	╛	Janes H.
Root	<u> </u>			Desc	ription of work order update		Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or non-conformance	Cŀ	nief Eng	Desc	ription	Date	Verification	,	QC Inspector
Design											-		
Doc/Data						1				,		- 1	
Equip/Tooling		}	1										
Handling/Pre													
Material		1											
Operator						ĺ				ľ			
Offset/Setup						ŀ							
Process		İ											
Supplier													
Training												1	
Transport		ļ	Ì			İ						-	
Unapproved			1										
						FA	ULT CAT	EGORY				•	
Landin	g Gear				General							·	
	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	$\Box$	Pressure/Forced
[	Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	<b>-</b>  :	Set-up
[	Cracks				Broken/Damage/Defect		Hardwa	re	<u> </u>	Part Incorred	et l	٦.	Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs	_	Inspecti	on Incomplete/U	ngualified	Part Lost/Mi	j-	$\neg$	Weld
<del> </del>	Cuffs				Contamination	厂	1	ions Incomplete/	· · · · · · · · · · · · · · · · · · ·	Part Moved	- 1	_	Wrong Stock Pulled
	Crushing				Countersink		4	ned/off center		Positioned V		_	
	Heat Tre				Cut Too Short		Mislabe		<u></u>	Power Loss/		$\Box$	Other
	Inspection	n Strip in	Tube		Drawing	$\Box$	Misread		<u> </u>	<b>_</b>	Č		· · ·
	Marks/C	•			Drill Holes	$\vdash$	Off-set					<del>-</del>	
		Sequence			Finish	Г	1	Calibration			<del></del>		
!		vist in Tub			Fit/Function	$\vdash$	4	Sequence					

Work Order ID: 104462

\*104462\*

Parent Item:

D3189-1

\*D3189-1\*

Parent Item Name: Chaffing Shield

**Start Date: 7/11/13** 

Required Date: 7/25/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B05.08.22No longer made in-houseKJ/JLM

IPP Rev:C 06-03-24 Rolling Now made in House JLM

IPP Rev:D 07-04-16 As per Rev B JLM

IPP Rev:E

11.05.11 now made on waterjet DD verf:JLM

Component Item ID/ Item Name	Replacement Item 1D	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304S28GA		Purchased	No		· <del></del>	100	sf —	0.0000	0.32	 6 <del>.73684</del> 2			_	i i
*M304S2	KGA*								**	7 ^			Tm B-	na -14

304/316 .020" Sheet

125771

125771

Z4GA

Page I

DQA:		<b>-</b> Date:			. MORK ORDER NON	c	NEO	DAMANCE / 11	DDATE			~DART
QA Closed:		Date:			WORK ORDER NON		ייייייייייייייייייייייייייייייייייייייי	RIVIAINCE / U		ork Order up	odate only	AEROSPACE
Work Order					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
Work Order:  Part No.  NCR No.			<del></del>	Rework Scrap Use-as-is Suspected Unapproved	Scrap Machining Small Factoring Small Factoring Finishing			Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other		
Doot	<del></del>	1	<u> </u>	Docc	ription of work order update		nitial	٨٥	tion	Sign &		<del></del>
Root	Date	Step	Qty	Desc	or non-conformance	1	iief Eng		ription	- Date	Verification	QC Inspector
Cause  Design  Doc/Data  Equip/Tooling  Handling/Pre  Material  Operator  Offset/Setup  Process  Supplier  Training  Transport	Date	step	Qty		or non-conformance		HET ENG	Desc	ription .	. Date	*	QC IIISPECTOI
Unapproved		<u> </u>	<u> </u>			EAL	HT CA	TEGORY		]	ļ	
Landing	Gear				General	FAI	ULT CA	regory		· · · · · · · · · · · · · · · · · · ·		
	Bending Centre N Cracks Crimp/Ki Cuffs Crushing Heat Tre Inspection	at on Strip in	e/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalig Mislabe Misread Off-set	ion Incomplete/U tions Incomplete/ gned/off center eled d		Outside Dim Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct issing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	<b>⊣</b>	wist in Tul			Fit/Function		4	Sequence				

DART AEROSPACE LTD	Work Order:	104462
Description: Chafing Shield	Part Number:	D3189-1
Inspection Dwg: D3189 Rev: C		Page 1 of 1

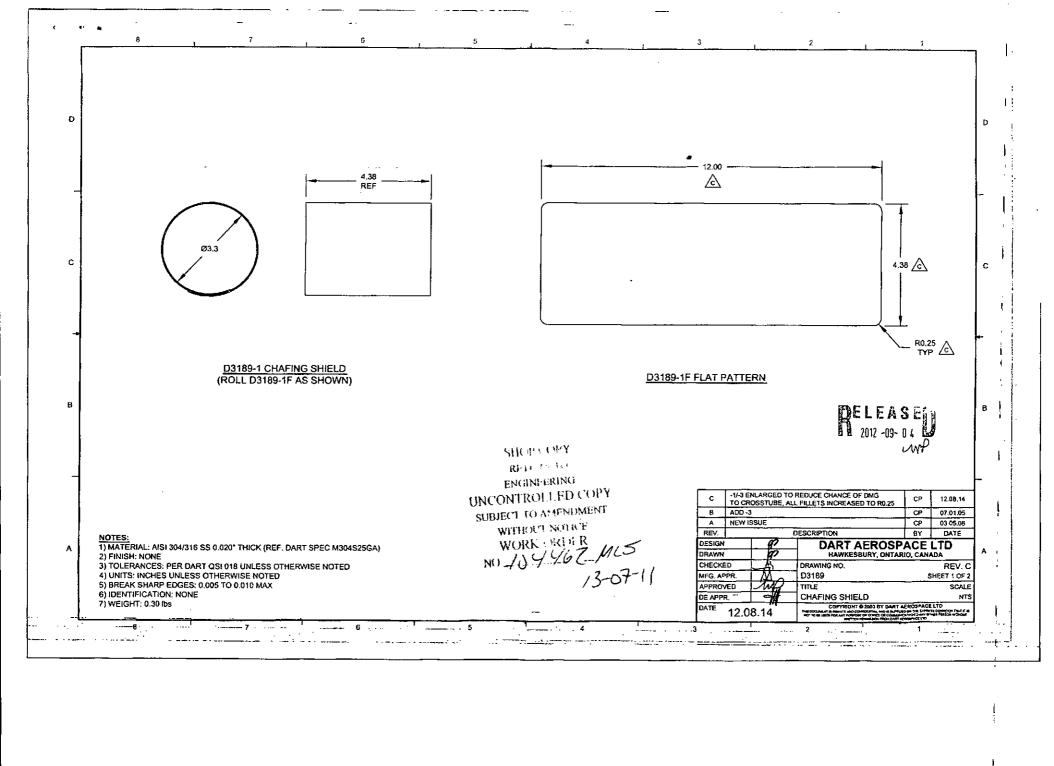
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.38	+/-0.030	4,386"	_		V	Jhmoi
12.00	+/-0.030	12.010			V	Jimoi Produgoz.
0.020	+/-0.010	<b>ది.ం</b> వి3ో	_		ע	
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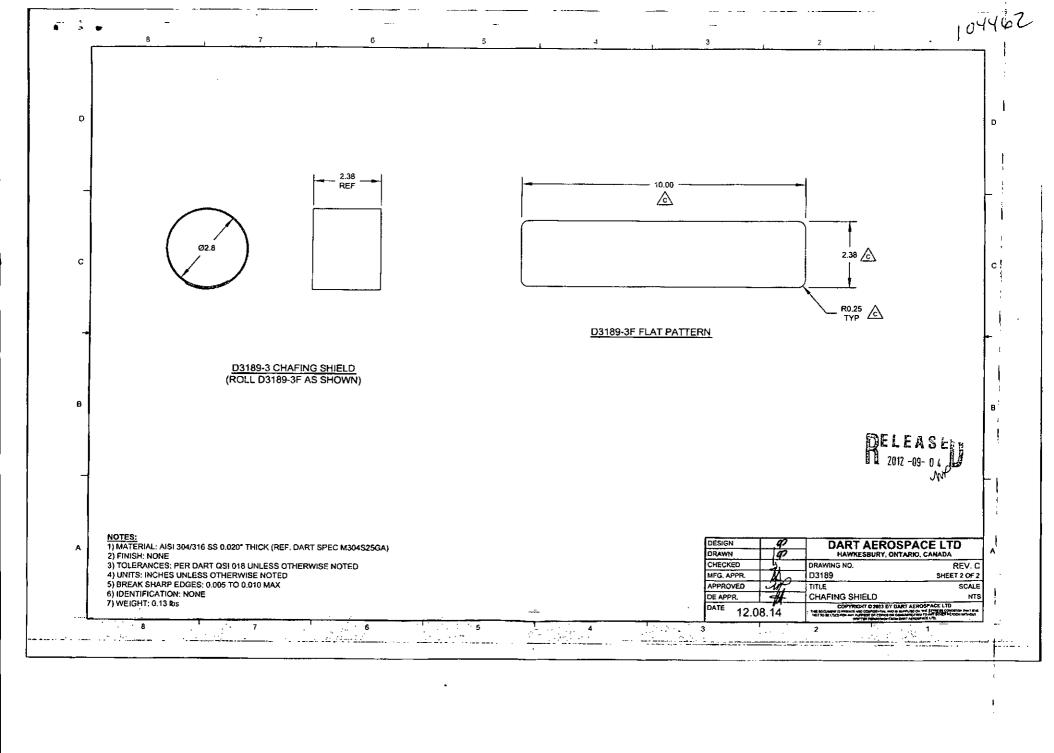
Measured by: Jm	Audited by: SW)	Preliminary Approval:
Date: (3.08-14	Date: 13 8.19	Date:

	Rev	Date	Change	Revis	sed by	Approved
- (	Α	11.06.21	New Issue	KJ	i\	
:	В	12.09.26	Dimensions updated per Dwg Rev C	KJ	THE	Choll
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